

13

Date: Thursday, 3/13/2008 1:01:39 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 212/205 HIGH FED X-TUBE ASSEMBLY |
| Job Number | : 37989 | | |
| Estimate Number | : 13216 | | |
| P.O. Number | : | Part Number | : D212664101TRN |
| This Issue | : 3/13/2008 S.O. No. : | Drawing Number | : D212-664-141 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LANDING GEAR | Drawing Revision | : C |
| Previous Run | : 37988 | Material | : |
| Written By | : | Due Date | : 3/28/2008 Qty: 1 Um: Each |
| Checked & Approved By | : <u>08.03.13</u> | | |
| Comment | : Est Rev:A 08-03-06 new issue DD verified by:ec | | |

Additional Product

Job Number:



| | | |
|--------|-----------------------|--------------|
| Seq. # | Machine Or Operation: | Description: |
|--------|-----------------------|--------------|

| | | |
|-----|----------|--------------------|
| 1.0 | D6005128 | Crosstube material |
|-----|----------|--------------------|

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| | | |
|--------------------------------|-------------|---------------|
| Qty Part number | Description | Batch |
| 1- D6005-128 | Crosstube | <u>B34686</u> |
| Check OD = 2.750"; ID = 2.000" | | |

a.m 08.03.28 ①

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|

Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113 a.m 08.03.31 ①

2-Turn first side as per Folio FA113 a.m 08.03.31 ①

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. a.m 08.03.31 ①

| | | |
|-----|-----|------------------------------|
| 3.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|

Comment: INSPECT ALL DIM TO DIM SHEET

a.m 08.03.31 ①

| | | |
|-----|------------|----------------------------|
| 4.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|

Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113 a.m 08.03.31

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. a.m 08.03.31

3-Remove sand and plugs a.m 08.03.31 ①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|---|--|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 37989 |
| Description: Crosstube Assembly (205/212/412 High Fwd) | | Part Number: | D212-664-141 |
| Inspection Dwg: D212-664-141 Rev: C | | Page 1 of 1 | |

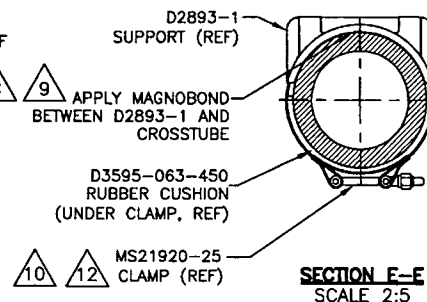
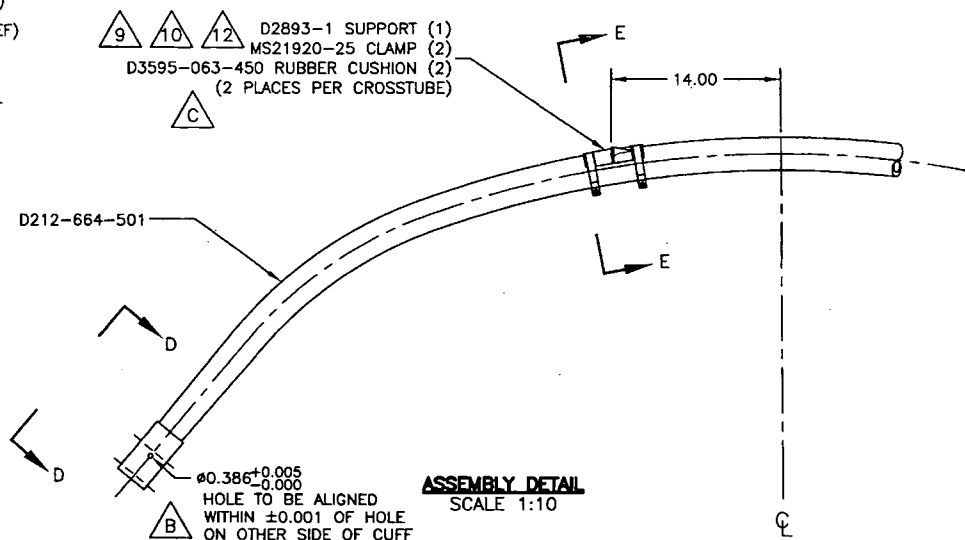
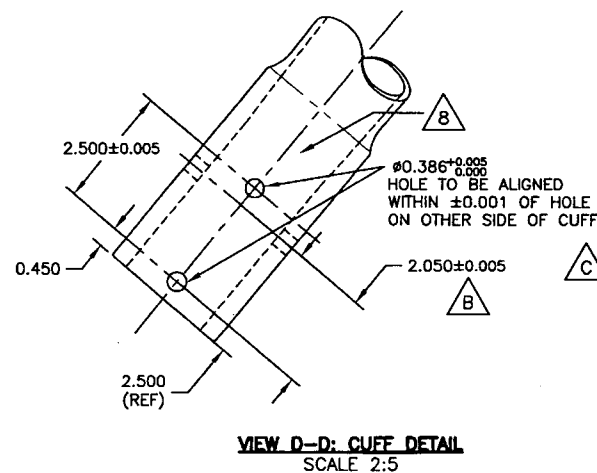
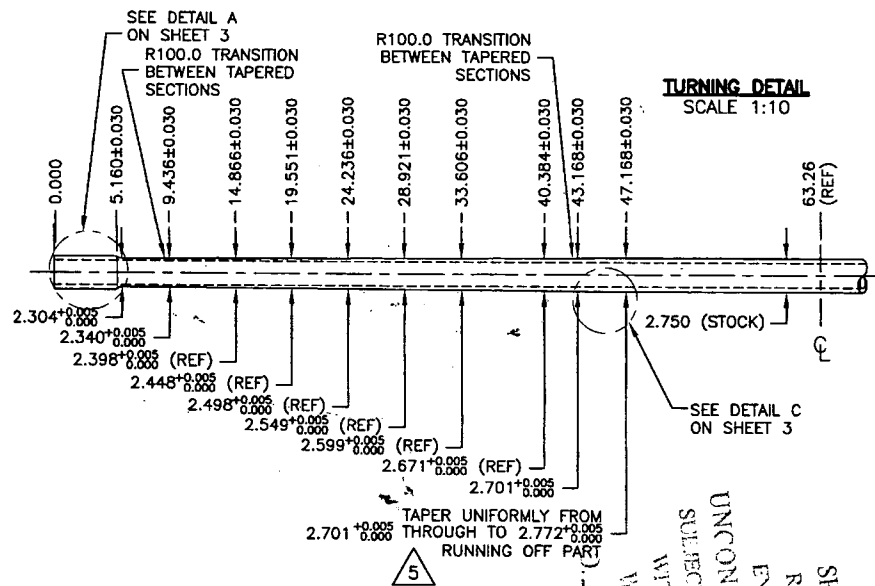
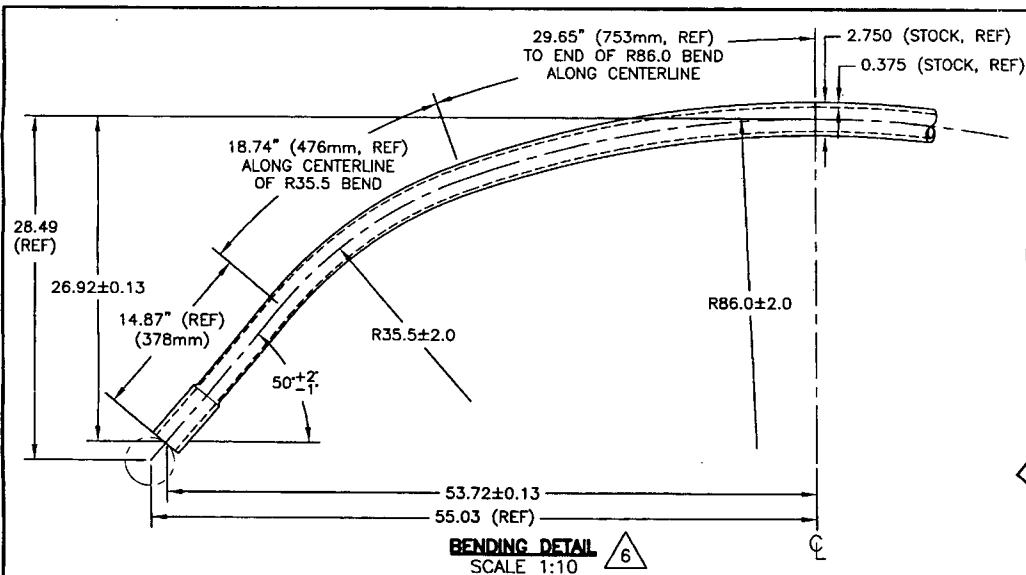
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 0.200 | +/-0.010 | 0.200 | | | |
| | R0.063 | +/-0.010 | R0.063 | | | |
| | 2.740 | +0.005/-0.000 | 2.740 | | | |
| | 5.097 | +/-0.030 | 5.097 | | | |
| | 2.304 | +0.005/-0.000 | 2.309 | | | |
| | 2.340 | +0.005/-0.000 | 2.345 | | | |
| | 2.398 | +0.005/-0.000 | 2.400 | | | |
| | 2.448 | +0.005/-0.000 | 2.451 | | | |
| | 2.498 | +0.005/-0.000 | 2.500 | | | |
| | 2.549 | +0.005/-0.000 | 2.554 | | | |
| | 2.599 | +0.005/-0.000 | 2.604 | | | |
| | 2.671 | +0.005/-0.000 | 2.676 | | | |
| | 2.701 | +0.005/-0.000 | 2.703 | | | |
| | | | | | | |
| SIDE B | 0.200 | +/-0.010 | 0.200 | | | |
| | R0.063 | +/-0.010 | R0.063 | | | |
| | 2.740 | +0.005/-0.000 | 2.745 | | | |
| | 5.097 | +/-0.030 | 5.115 | | | |
| | 2.304 | +0.005/-0.000 | 2.309 | | | |
| | 2.340 | +0.005/-0.000 | 2.344 | | | |
| | 2.398 | +0.005/-0.000 | 2.403 | | | |
| | 2.448 | +0.005/-0.000 | 2.451 | | | |
| | 2.498 | +0.005/-0.000 | 2.500 | | | |
| | 2.549 | +0.005/-0.000 | 2.553 | | | |
| | 2.599 | +0.005/-0.000 | 2.602 | | | |
| | 2.671 | +0.005/-0.000 | 2.674 | | | |
| | 2.701 | +0.005/-0.000 | 2.704 | | | |
| | 126.51 | +/-0.020 | 126.51 | | | |

| | | | | | |
|---------------------|----------|--------------------|--|----------------------------|-----|
| Measured by: | R.m | Audited by: | | Prototype Approval: | N/A |
| Date: | 08.03.31 | Date: | | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | 05.04.27 | New Issue (P/O D412-664-101) | KJ/JLM | |
| B | 06.03.15 | Tolerance revised for 5.097 per Dwg Rev update | KJ/JLM | |
| C | 07.05.28 | Dwg Rev updated | KJ/JLM | |



RELEASED

07.04.24

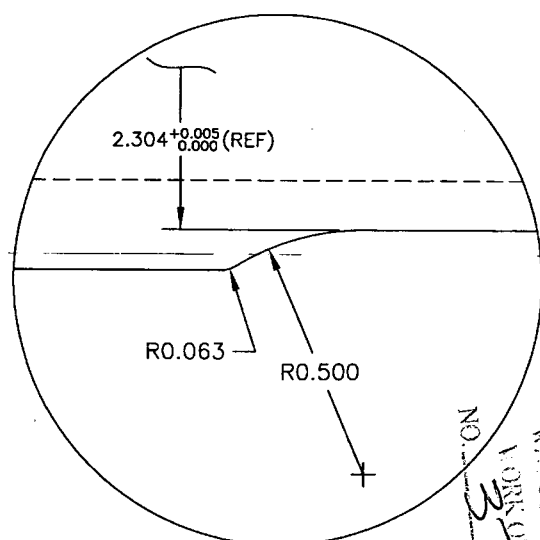
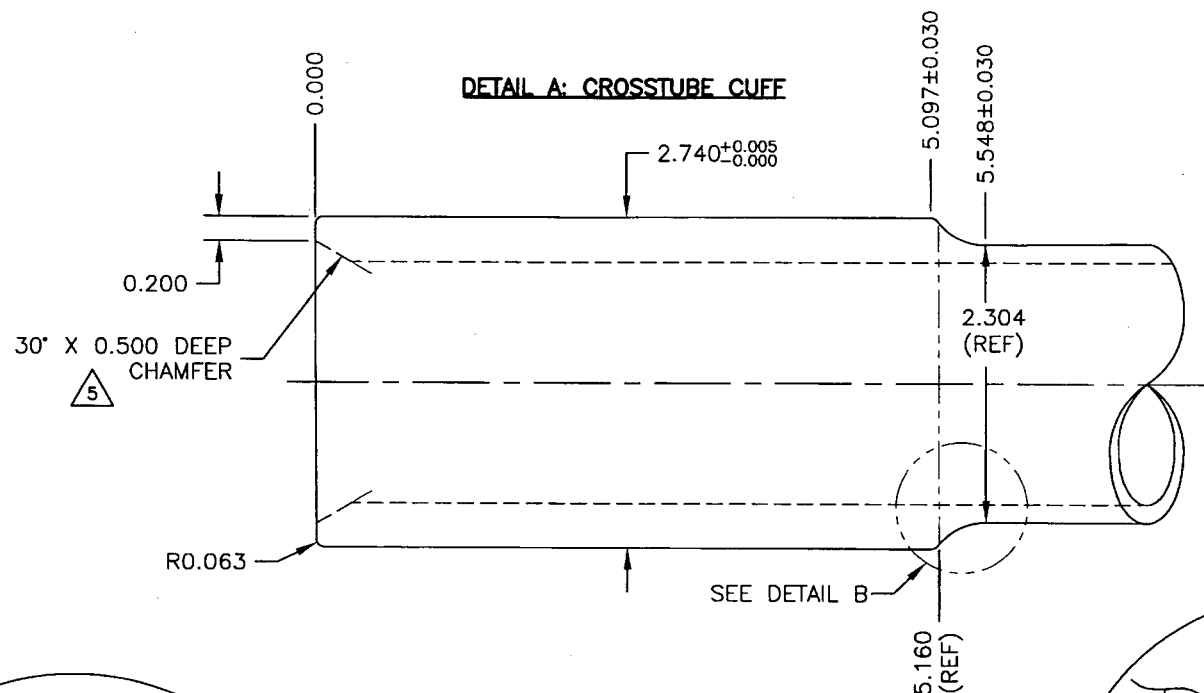
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| | | | | | |
|---------|----------|----------|----------------------------------|-------------|--|
| DESIGN | PH | DRAWN BY | PH | DART | DART AEROSPACE LTD. WARRISBURY, ONTARIO, CANADA |
| CHECKED | 92 | APPROVED | 4 | DRAWING NO. | REV. C |
| DATE | 07.03.08 | TITLE | XTUBE ASS'Y (205/212/412 HI FWD) | 1:10 | SHEET 2 OF 3 |

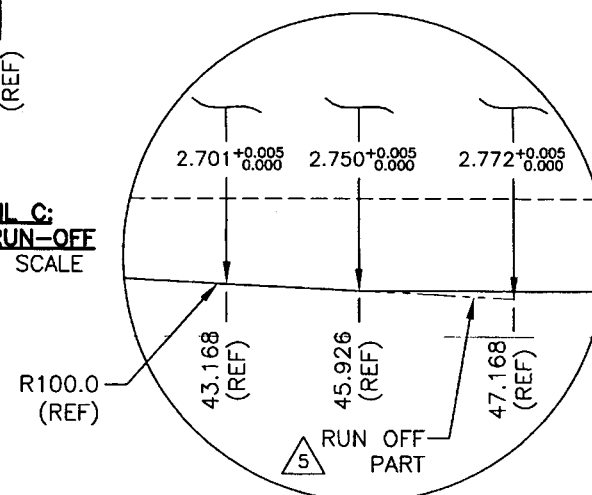
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37489

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67.04.24 (P)
PER E.N. 887



**DETAIL B: CUFF
TRANSITION**
SCALE 4:1

**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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| | | | |
|------------------|---|-----------------------------|---|
| DESIGN PH | DRAWN BY PH | DART | DART AEROSPACE LTD. MARKESBURY, OXFORD, CANADA |
| CHECKED J | APPROVED J | DRAWING NO. D212-664-141 | REV. C SHEET 3 OF 3 |
| DATE 07.03.08 | TITLE XTUBE ASS'Y (205/212/412 HI FWD) | SCALE 1:1 | |

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